

Work Order ID 85088***85088***

Page 1

Friday, June 01, 2012 3:27:30 PM

Item ID: PB67-43001-03

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Aft Blade Fold Assembly

Stop ***NS2***

Start Date: 6/1/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *mf*Date: *12.06.27* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

B67-43001-03

Rev C

Pick k.7

0.00

100

100

Small Fab

0.00

Small Fab

Memo

Small Fab

1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001
page 2. 242 THREADLOCK batch:*Touch up Paint Batch # M112961*

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

120

Identify as per dwg & Stock Location: _____

0.00

120

Packaging

Memo

0.00

Packaging

12/6/27
12.06.27
12.06.27

*S1764129**(Y1)**12/6/27*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 2

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Revision ID:

Stop ***NS2***

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Start Date: 6/1/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

12/7/10

MF
12-06-29

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Picklist Print

Friday, June 01, 2012 3:27:29 PM

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Parent Item Name: Aft Blade Fold Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-07-30 new issue DD verified by:ec
IPP Rev:B 08-12-04 up date part list DD Verified by:ec IPP Rev C 10.09.24 as per Rev
C dwg EC verified by:DD IPP Rev:D 10.10.21 added NAS1149F0532P DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
240-107 SPRING SLOTTED PIN		Purchased	No			100	Each	82.0000	8	8	122090	sf	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST400		82							
				115827		82							
30345T21 LANYARD		Purchased	No			100	Each	37.0000	1	1	50		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST401		37							
				17828		37							
30345T24 LANYARDS		Purchased	No			100	Each	42.0000	3	3	50		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST401		42							
				112853		42							
3408A98 DETENT BALL SPRING PLUNG		Purchased	No			100	Each	13.0000	1	1	30		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST401		13							
				111078		3							
				115703		10							
AN4-10A Bolt		Purchased	No			100	Each	81.0000	2	2	121610	sf	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST356		81							
				117619		31							
				121666		50							

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Picklist Print

Friday, June 01, 2012 3:27:29 PM

Page 2

Work Order ID: 85088

Parent Item: PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

AN4-13A Purchased No

100 Each 1,261.0000 1 1

Bolt

Location	Loc Qty	Loc Code
ST357	1261	
119449	33	
120187	19	
120422	2	
120770	207	
121652	1000	

AN4-15A Purchased No

100 Each 527.0000 4 4

Bolt

Location	Loc Qty	Loc Code
358	100	
121652	100	
GA	100	
120449	100	
ST358	327	
118706	3	
120422	24	
121444	100	
121541	200	

AN5-26A Purchased No

100 Each 16.0000 1 1

Bolt

Location	Loc Qty	Loc Code
ST339	16	
112492	16	

AN6-11A Purchased No

100 Each 71.0000 2 2

BOLT

Location	Loc Qty	Loc Code
ST341	71	
111177	21	
114437	50	

Friday, June 01, 2012 3:27:29 PM

Shop Packet Print

Page 2

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Friday, June 01, 2012 3:27:29 PM

Page 3

Work Order ID: 85088

Parent Item: PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

AN6-16A Purchased No 100 Each 33.0000 2 2

BOLT

Location Loc Qty Loc Code

ST341 33

111636 33

AN8-13A Purchased No 100 Each 14.0000 2 2

BOLT

Location Loc Qty Loc Code

ST343 14

110915 14

BSP43 Purchased No 100 Each 55.0000 3 3

RIVET

Location Loc Qty Loc Code

ST284 55

110704 50

111127 5

CR3213-4-05 Purchased No 100 Each 141.0000 1 1

cherry rivet

Location Loc Qty Loc Code

ST331 141

108473 41

108991 100

D3440-1 Manufactured No 100 Each 10.0000 1 1

Tube Guide (Supersedes B67-43001-25/-307)

Location Loc Qty Loc Code

ST439A 10

40047 8

41347 2

D3440-3 Manufactured No 100 Each 2.0000 1 1

Clamp (Supersedes B67-43001-309)

Location Loc Qty Loc Code

ST439A 2

41348 2

Friday, June 01, 2012 3:27:29 PM

Shop Packet Print

Page 3

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Friday, June 01, 2012 3:27:29 PM

Page 4

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Parent Item: PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

D3444-1 Manufactured No 100 Each 7.0000
Velcro Loop Belt

Location Loc Qty Loc Code

ST439A 7

41457 7

D3447-9 Manufactured No 100 Each 8.0000
Swing Arm

Location Loc Qty Loc Code

ST440 8

57745 4

62127 4

D3449-1 Manufactured No 100 Each 5.0000
Pad

Location Loc Qty Loc Code

ST440 5

62128 5

D3451-043 Manufactured No 100 Each 1.0000
Handle and Lock-Down Assembly

Location Loc Qty Loc Code

ST442 1

52566 1

D3451-045 Manufactured No 100 Each 1.0000
Handle and Lock-Down Assembly

Location Loc Qty Loc Code

ST442 1

52567 1

D3922-1 Manufactured No Each 42.0000
Clip

Location Loc Qty Loc Code

ST070 42

66852 42

Friday, June 01, 2012 3:27:29 PM

Shop Packet Print

Page 4

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Friday, June 01, 2012 3:27:29 PM

Page 5

Work Order ID: 85088

Parent Item: PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

MS17984-C408
PIN, QUICK RELEASE

Purchased

No

Each 8.0000

1

Location

Loc Qty

Loc Code

ST314

8

112940

8

MS17984-C418
PIN, QUICK RELEASE

Purchased

No

100 Each 20.0000

3

3

Location

Loc Qty

Loc Code

ST315

20

114416

3

114523

15 17

MS21042L4
Nut

Purchased

No

100 Each 3.910.0000

9

9

Location

Loc Qty

Loc Code

ST300

3910

119075

116

121011

537

121444

2957

121652

300

MS21042L5
Nut

Purchased

No

100 Each 1.417.0000

1

1

Location

Loc Qty

Loc Code

300

500

121652

500

ST300

917

108827

8

116105

5

116548

43

117611

18

119109

835

17651

8

Friday, June 01, 2012 3:27:30 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Friday, June 01, 2012 3:27:30 PM

Page 6

Work Order ID: 85088
Parent Item: PB67-43001-03
Parent Item Name: Aft Blade Fold Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L6 Purchased No

100 Each 648.0000 4 4

Nut

Location

Loc Qty

Loc Code

ST300

648

117677

25

118384

3

118927

48

119075

372

120308

200

MS24694-S109

Purchased No

100 Each 50.0000 2 2

Screw, Flat Head

Location

Loc Qty

Loc Code

Mezz

50

115708

50

MS27039-1-07

Purchased No

100 Each 78.0000 1 1

Screw

Location

Loc Qty

Loc Code

ST291

78

18106

78

MS27039-1-23

Purchased No

100 Each 28.0000 1 1

SCREW

Location

Loc Qty

Loc Code

ST291

28

18057

28

MS51859-6

Purchased No

100 Each 108.0000 8 8

WASHER

Location

Loc Qty

Loc Code

ST296

108

111279

8

112940

100

Friday, June 01, 2012 3:27:30 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Friday, June 01, 2012 3:27:30 PM

Page 7

Work Order ID: 85088
Parent Item: PB67-43001-03
Parent Item Name: Aft Blade Fold Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

MS51859-7 Purchased No

100 Each 22.0000 2 2

Washer

Location

Loc Qty

Loc Code

ST296

22

111193

12

~~120518~~

10

MS51859-8 Purchased No

100 Each 46.0000 8 8

WASHER

Location

Loc Qty

Loc Code

ST296

46

112940

46

NAS1149F0316P Purchased No

100 Each 245.0000 1 1

WASHER

Location

Loc Qty

Loc Code

ST275

245

112940

45

~~113237~~

100

113644

100

NAS1149F0432P Purchased No

100 Each 792.0000 16 16

Washer

Location

Loc Qty

Loc Code

ST275

792

121350

792

NAS1149F0532P Purchased No

100 Each 1,105.0000 2 2

WASHER

Location

Loc Qty

Loc Code

ST275

1105

18057

1105

NAS1149F0632P Purchased No

100 Each 465.0000 8 8

WASHER

Location

Loc Qty

Loc Code

ST275

465

18057

465

Friday, June 01, 2012 3:27:30 PM

Shop Packet Print

Page 7

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Picklist Print

Friday, June 01, 2012 3:27:30 PM

Page 8

Work Order ID: 85088

Parent Item: PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0832P

Purchased

No

100

Each

248 0000

2

2

WASHER

Location

Loc Qty

Loc Code

ST275

248

18057

248

NAS43DD3-61

Purchased

No

100

Each

0.0000

1

Spacer

PB67-43001-09

Manufactured

No

100

Each

0.0000

1

Aft Blade Fold Assembly Weldment

PB67-43001-13

Manufactured

No

100

Each

0.0000

1

Aft Adjustable Blade Support Assembly

PB67-43001-135

Manufactured

No

100

Each

5.0000

1

Male Eye

Location

Loc Qty

Loc Code

ST446

5

45000

5

PB67-43001-137

Manufactured

No

100

Each

0.0000

1

Locking Sleeve

PB67-43001-155

Manufactured

No

100

Each

12.0000

1

Pin

Location

Loc Qty

Loc Code

ST446A

12

43092

12

PB67-43001-17

Manufactured

No

100

Each

0.0000

1

Aft Adjustable Blade Support Assembly

PB67-43001-21

Manufactured

No

100

Each

0.0000

1

PB67-43001-21

PB67-43001-23

Manufactured

No

100

Each

0.0000

1

PB67-43001-23

PB67-43001-23

Friday, June 01, 2012 3:27:30 PM

Shop Packet Print

Page 8

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Friday, June 01, 2012 3:27:30 PM

Page 9

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Parent Item: PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-261

Manufactured

No

100

Each

12.0000

2

2

Lever Arm

Location

Loc Qty

Loc Code

ST432

12

62182

12

PB67-43001-265

Manufactured

No

100

Each

11.0000

5

5

Deltin Bushing

Location

Loc Qty

Loc Code

ST438

11

40056

11

PB67-43001-299

Manufactured

No

100

Each

17.0000

2

2

Bushing

Location

Loc Qty

Loc Code

ST439A

17

44969

17

PB67-43001-305

Manufactured

No

100

Each

2.0000

1

1

Bearing

Location

Loc Qty

Loc Code

ST439

2

47044

2

PB67-43001-37

Manufactured

No

100

Each

0.0000

1

1

Tube Arm Assembly

PB67-43001-57

Manufactured

No

100

Each

1.0000

1

1

Stabilizer Arm

Location

Loc Qty

Loc Code

Mezz

1

62129

1

PB67-43001-59

Manufactured

No

100

Each

0.0000

1

1

PB67-43001-59

BSS/08

Friday, June 01, 2012 3:27:30 PM

Shop Packet Print

Page 9

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Friday, June 01, 2012 3:27:30 PM

Page 10

Work Order ID: 85088

Parent Item: PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-63

Manufactured

No

100

Each

1.0000

1

1

Handle Assembly

Location

Loc Qty

Loc Code

Mezz

1

53243

1

1

Friday, June 01, 2012 3:27:30 PM

Shop Packet Print

Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

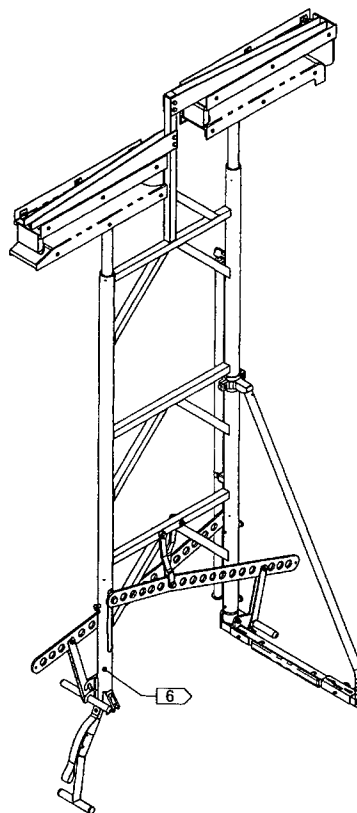
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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ITEM	QTY -03	P/N	DESCRIPTION
	X	B67-43001-03	AFT BLADE FOLD ASSY
1	1	B67-43001-09	AFT BLADE FOLD ASSY WELDMENT
2	1	B67-43001-13	AFT ADJUSTABLE BLADE SUPPORT ASSY
3	1	B67-43001-17	AFT ADJUSTABLE BLADE SUPPORT ASSY
4	1	B67-43001-21	UPPER BLADE SUPPORT AND COVER ASSY
5	1	B67-43001-23	LOWER BLADE SUPPORT AND COVER ASSY
6	1	B67-43001-37	TUBE ARM ASSEMBLY
7	1	B67-43001-57	STABILIZER ARM
8	1	B67-43001-59	ADJUSTABLE ATTACHMENT ARM
9	1	B67-43001-63	SHORT T-HANDLE ASSEMBLY
10	1	B67-43001-135	MALE EYE
11	1	B67-43001-137	LOCKING SLEEVE
12	1	B67-43001-155	PIN
13	2	B67-43001-261	LEVER ARM
14	5	B67-43001-265	DELFIN BUSHING
15	2	B67-43001-299	BUSHING
16	1	B67-43001-305	BEARING
17	1	D3440-1	TUBE GUIDE
18	1	D3440-3	CLAMP
19	1	D3444-1	VELCRO LOOP BELT
20	2	D3447-9	SWING ARM
21	1	D3449-1	PAD
22	1	D3451-043	HANDLE & LOCK-DOWN ASSY
23	1	D3451-045	HANDLE & LOCK-DOWN ASSY
24	1	D3922-1	CLIP
25	1	30345T21	LANYARD
26	3	30345T24	LANYARD
27	1	3408A98	DETENT BALL PLUNGER
29	2	AN4-10A	BOLT
30	1	AN4-13A	BOLT
31	4	AN4-15A	BOLT
32	1	AN5-26A	BOLT
33	2	AN6-11A	BOLT
34	2	AN6-16A	BOLT
35	2	AN8-13A	BOLT
36	3	BSP43	RIVET
37	1	CR3213-4-05	RIVET
38	8	MS171534	SPRING SLOTTED TENSION PIN (OR 240-107)
39	1	MS17984-C408	QUICK RELEASE PIN
40	3	MS17984-C418	QUICK RELEASE PIN
41	9	MS21042L4	NUT
42	1	MS21042L5	NUT
43	4	MS21042L6	NUT
44	2	MS24694-S109	SCREW
45	1	MS27039-1-07	SCREW
46	1	MS27039-1-23	SCREW
47	8	MS51859-6	NYLON WASHER
48	2	MS51859-7	NYLON WASHER
49	8	MS51859-8	NYLON WASHER

ITEM	QTY -03	P/N	DESCRIPTION
	X	B67-43001-03	AFT BLADE FOLD ASSY
50	1	NAS43DD3-61	SPACER
51	4	NAS1149DN632J	WASHER
52	1	NAS1149F0316P	WASHER
53	16	NAS1149F0432P	WASHER
54	2	NAS1149F0532P	WASHER
55	8	NAS1149F0632P	WASHER
56	2	NAS1149F0832P	WASHER



B67-43001-03 AFT BLADE FOLD ASSY

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: TOUCH UP PAINT WITH SANDFLEX GREEN.
POSSIBLE SUPPLIER BERTRAND BODY SHOP SUPPLIES
P/N DART01K
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH RED LABEL
- 7) WEIGHT: 50.57 lbs
- 8) WITH THE INNER TUBE CRADLE ASSEMBLY LOCKED IN ITS LOWEST MOST RECESSED POSITION, TRANSFER DRILL $\phi 0.250$ DIA HOLE FROM THE OUTER TUBE TO THE INNER TUBE AND THRU THE OUTER TUBE. DEBURR, REMOVE DEBRIS, AND TOUCH UP PAINT PER ITEM 2 AS REQUIRED. 2 PL.
- 9) INSTALL TEFLON BUSHING -265 INSIDE THE OUTER TUBE. MATCH DRILL BUSHING TO EXISTING HOLES IN OUTER TUBE USING $1/8"$ DIAMETER DRILL. INSERT MS171534 (OR 240170) SPRING SLOTTED PIN AND GRIND FLUSH WITH CONTOUR OF OUTER TUBE.
10 PL (2 PL PER BUSHING)
- 10) DRILL $\phi 0.250$ DIA HOLE THRU -09/-265/-305 WITH -37 AT VERTICAL FULL OPEN POSITION. DRILL ADDITIONAL HOLE WITH -37 AT FULL CLOSED POSITION, ASSURING -37 CLEARS ADJACENT STRUCTURE.
- 12) DRILL A $\phi 0.128$ DIA HOLE THRU -343 (COMPONENT OF -37) AND -25 (COMPONENT OF -09 ASSY). INSERT MS171534 (OR 240170) SPRING SLOTTED PIN, AND GRIND FLUSH WITH -37.
- 13) INSERT -135 INTO -243 TUBE (COMPONENT OF -09 ASSY) ALIGN HOLES, ASSURING ORIENTATION SHOWN. INSERT 3408A98 DETENT BALL, ASSURING BALL PROTRUDES SLIGHTLY ABOVE OUTER SURFACE OF -243 TUBE. LOCATE AND INSTALL AN MS171534 (OR 240170) SPRING SLOTTED PIN BY DRILLING A $\phi 0.128$ DIA HOLE THRU -243 AND -135. ENSURE -137 SLEEVE SLIDES FREELY OVER HINGE AND LOCKS INTO DETENT.
- 14) BOND D3449-1 TO B67-43001-09 USING CONTACT CEMENT AS PER MANUFACTURER'S SPECIFICATION.

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2010-09-21
JMP

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 3 OF PREMIER AVIATION DRAWING No. B67-43001 REASON: SEE PAR#09-011	VS	10.06.14
REV	DESCRIPTION	BY	DATE
DESIGN	RW		
DRAWN	VS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.06.14		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **B67-43001-03** REV. C
SHEET 1 OF 5
TITLE **AFT BLADE FOLD ASSY** SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

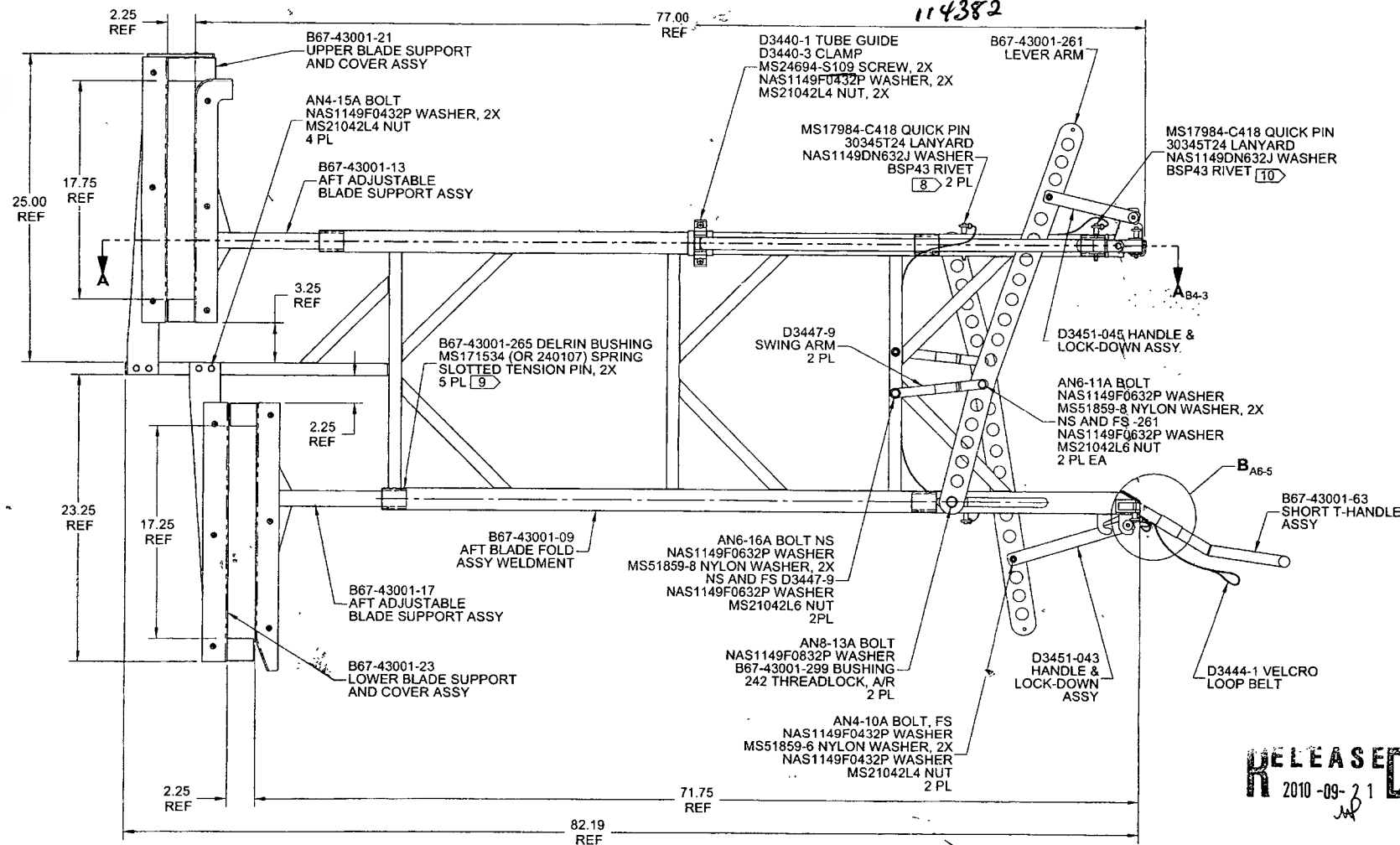
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____




NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



B67-43001-03 AFT BLADE FOLD ASSY

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MFG. APPR.		B67-43001-03	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.	N/A	AFT BLADE FOLD ASSY	NTS
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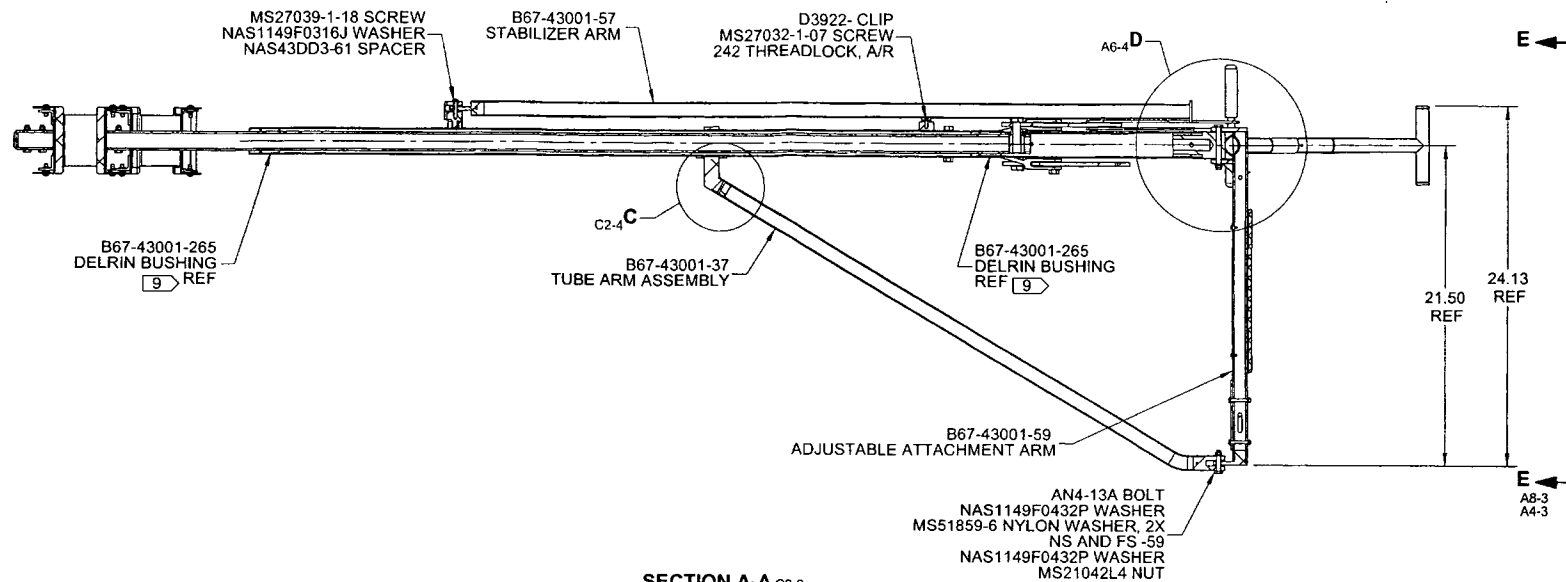
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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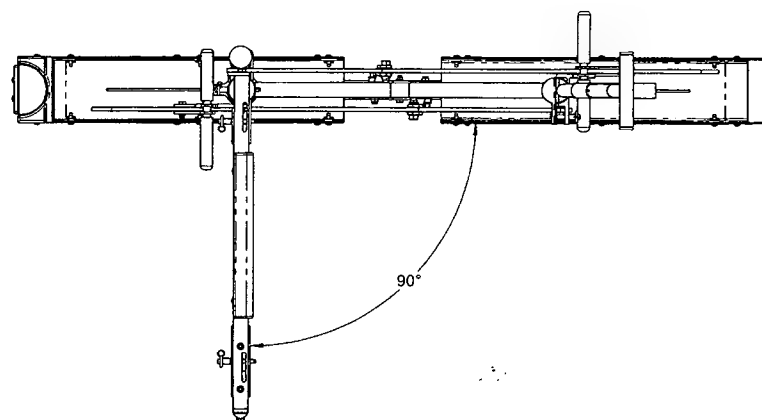
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

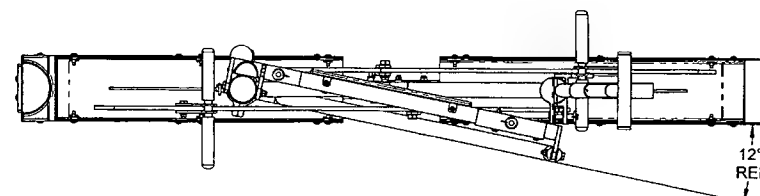
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SECTION A-A C2-2



C1-3 VIEW E-E: VERTICAL FULL OPEN OR "IN USE" POSITION 10



C1-3 VIEW E-E: FULL CLOSED OR "STORAGE" POSITION 10

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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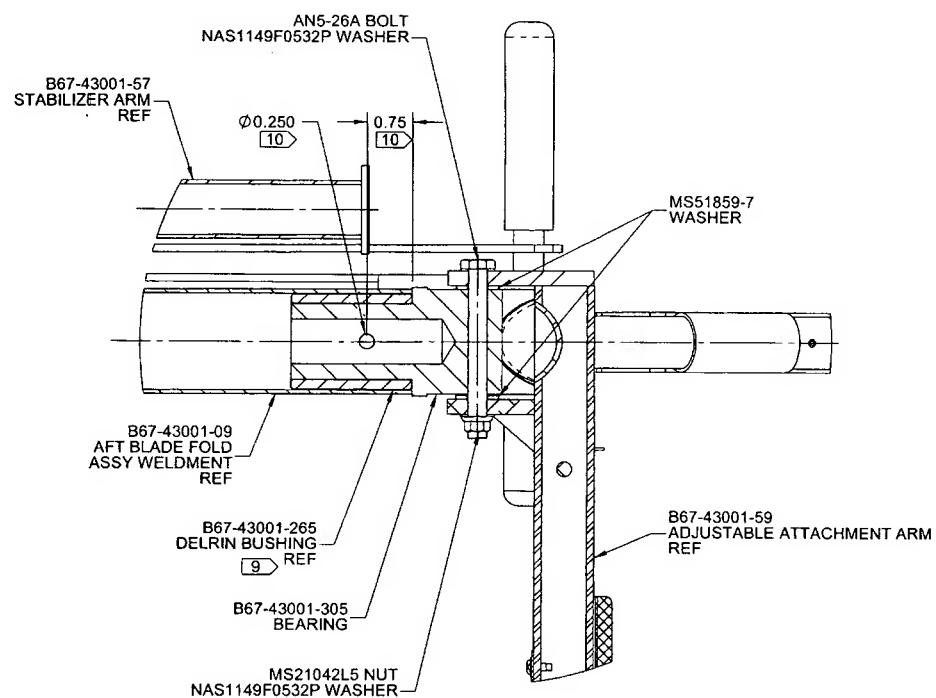
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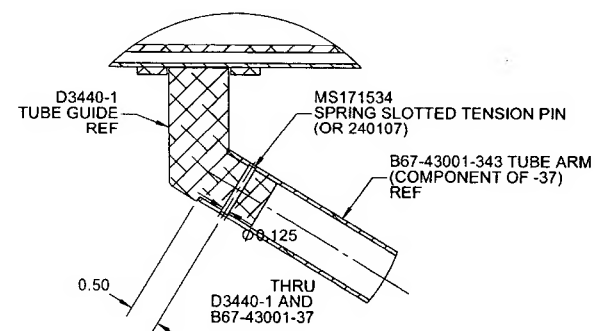
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2

1



DETAIL D
SCALE 5X D3-3



DETAIL C D5-3
SCALE 5X

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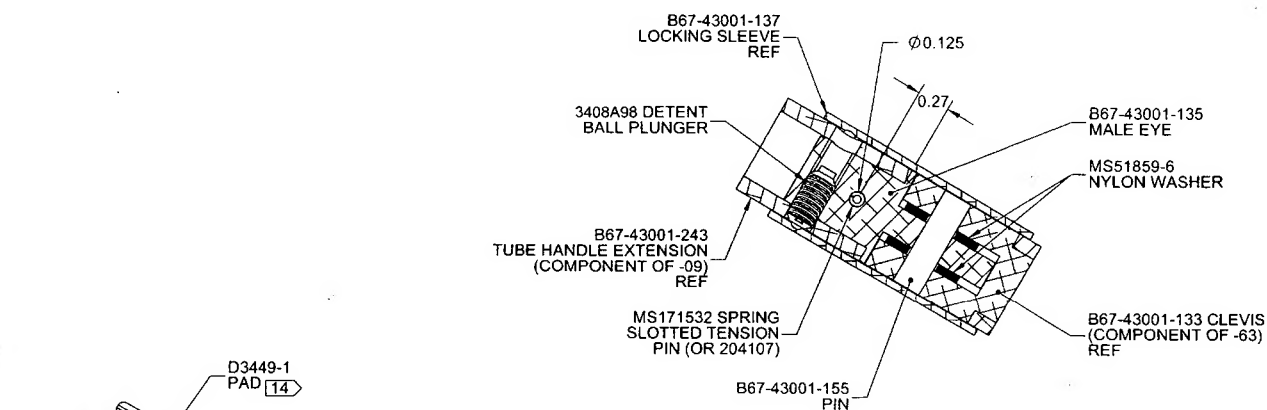
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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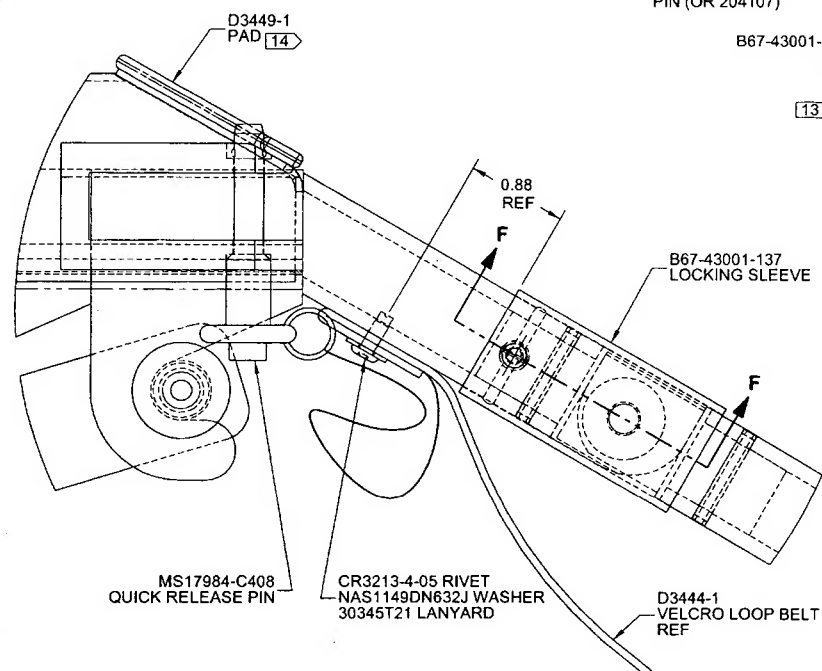
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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13 SECTION F-F B4-5



13 DETAIL B C2-2
SCALE 10X

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